

5/14

DART AEROSPACE LTD	Work Order:	22762
Description: Console Side RH (206 Hi-Slope)	Part Number:	D2602-2
Note: Issue with Part Number D2602-1		
Dwg: D2602 Rev. A1	Qty:	20
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: To be made in multiples of 10	EP	05.03.17	20
2	MV	Cut Blank per template DT8243 Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch M16302	EP	05/04/05	20
3	MV	Machine as per Folio FA145 and Dwg D2602 Stack of 10 Identify as D2602-2	EP	05/04/06	20
4	QC2	Inspect parts as they come off the CNC machine	EP	05/04/06	20
5	QC8	Second check	EP	05.04.06	20
6	GA	Deburr	EP	05/04/11	20
7	GB	Form as per Dwg D2602	EP	05/04/12	20
8	QC5	Inspect work to Step 7	EP	05.04.15	20
9	FP	Acid etch and Alodine as per QSI 005 4.1.	ML	05-04-15	20
10	QC3	Inspect work to Step 9	ML	05-04-15	20
11	ST	Identify and Stock	ML	05-04-15	20
12	AC	Cost / part 14.92	Sur	05.04.19	20
13	DC	Close W/O 14.71 Inspect Level 21	EP	05.04.26	20

Rev	Date	Change	Revised By	Approved
A	96.07.27	New Issue		
B	98.05.08	Added drawing revision	KB	
C	98.11.25	Added Inspection Levels	DM	
D	02.06.04	Added Alodine finish TSR 1290	NG	
E	04.02.25	Reformat	KJ/RF	

RELEASED

05/04/05-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 22762		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/04/12	7	Some parts .005 .010 have .03 to .04 more than tolerance	CP	when bending: pair up similar parts & maintain 0.674" flange dimensions REF: W/O 22761	SB 05/04/12	AS-04-26	CP 05.04.26 per QSI 42	IB 05.04.26

Part No: D2602-2 PAR #: _____ Fault Category: Prod./Inp. machining NCR: Yes No DQA: 9 Date: 05/04/2012

NOTE: Date & initial all entries

QA: N/C Closed: KA

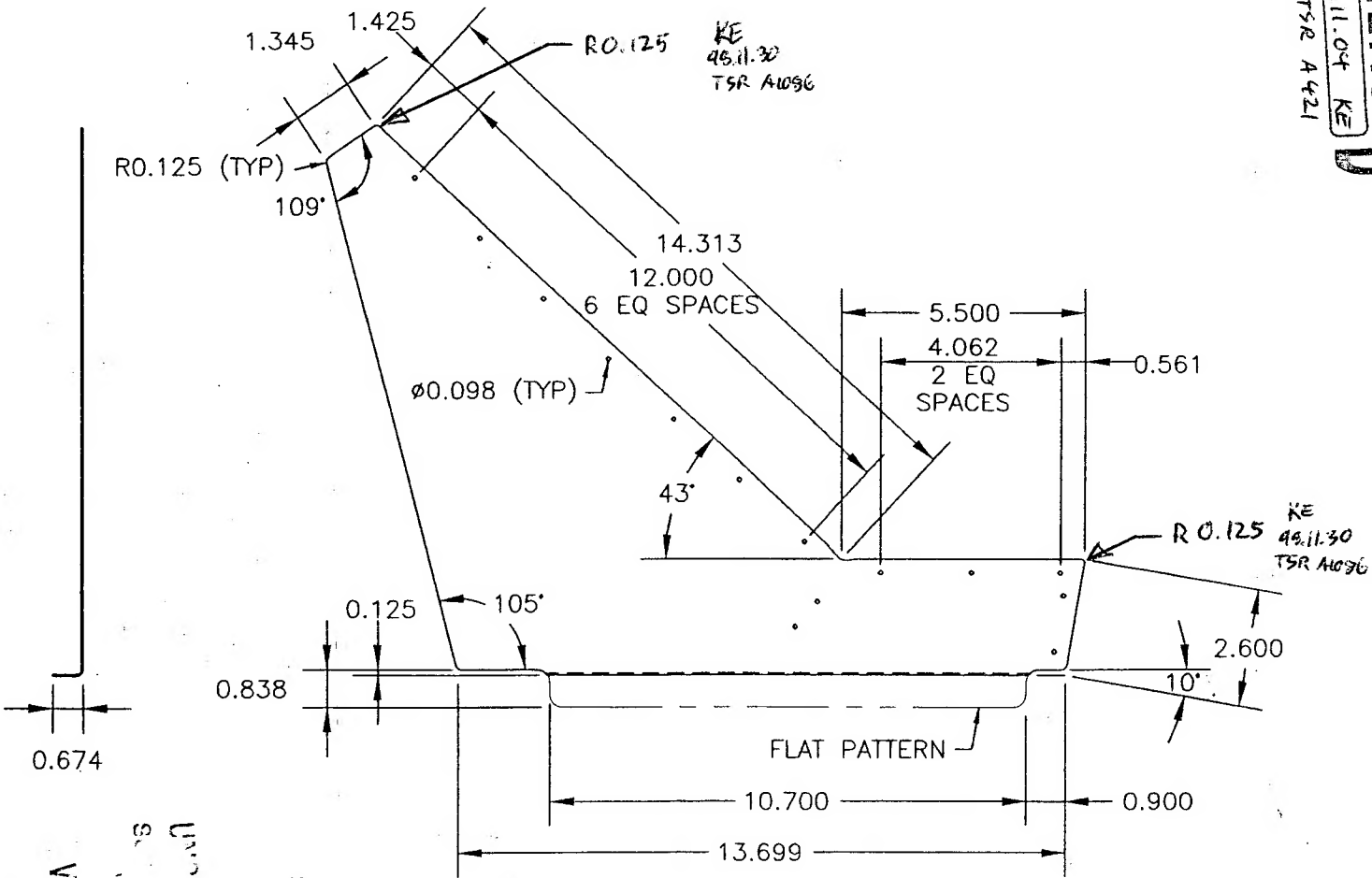
Date: 05.04.26

DART

QC COPY ISSUED

RELEASED
97.11.04 KE
TSR A421

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED KE	APPROVED Bw	DRAWING NO. D2602
DATE 97.10.22	TITLE CONSOLE SIDE	REV. A SHEET 1 OF 1
A	97.10.22	D2602 WAS D206-547-21/-22
AI	97.06.04	ADD FINISH



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
 PROFILE CONTROLLED BY FOLIO H2602
 BEND RADIUS 0.093
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 605 4.1
 D2602-1 SHOWN
 D2602-2 OPPOSITE

SHOP COPY
 RETURN TO
 ENGINEERING
 UNLESS OTHERWISE NOTED
 WORK ORDER
 NO. 22762

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Mar 17, 2005
02:16 pm

Work Order No : 0022762
Project Name : D2602-2
Project For : WK514
Work Order Type : Main
Main WO Number :
House Part Number : D2602-2
Description : Console Side Hi Slope
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 03-17-05
Est Finish Date : 04-07-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00